

Date: Tuesday, 04/11/2008 10:29:37 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 43184 - 1
 Estimate Number : 12967
 P.O. Number :
 This Issue : 04/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D36373
 Drawing Number : D3637 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 11/11/2008 Qty: 24 Um: Each
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 42823
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC
 Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.1407 sf(s)/Unit Total : 3.3768 sf(s)
 2024-T3 .050 sheet
 Batch: 107711 IB 8-11-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3637
 Dwg Rev: B
 Prog Rev: B

IB 8-11-4

(40)

2-Deburr if necessary IB 8-11-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

806/4/04 counter (40)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Form as per Dwg D3637

SB 08/11/05 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>43184</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.11.04	5	RO.16 was cracking	RA 08.11.04	change to RO.18 - NO MORE CRACKING PRESENT	RA 08.10.04	S 08.10.04	RA 08.11.04	S 08.11.04

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43184

Part Number: D36373

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sokolos (X)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- drill holes as per dwg using DT8979
- 2- c'sink holes as per dwg
- 3-deburr

08/11/05 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ob. 10/01/05

ENG'G APPROVAL

Sokolos (X)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FR 08/11/05

(4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-f 08/11/05 (4X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *261*

8/11/05

(4X)

SP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



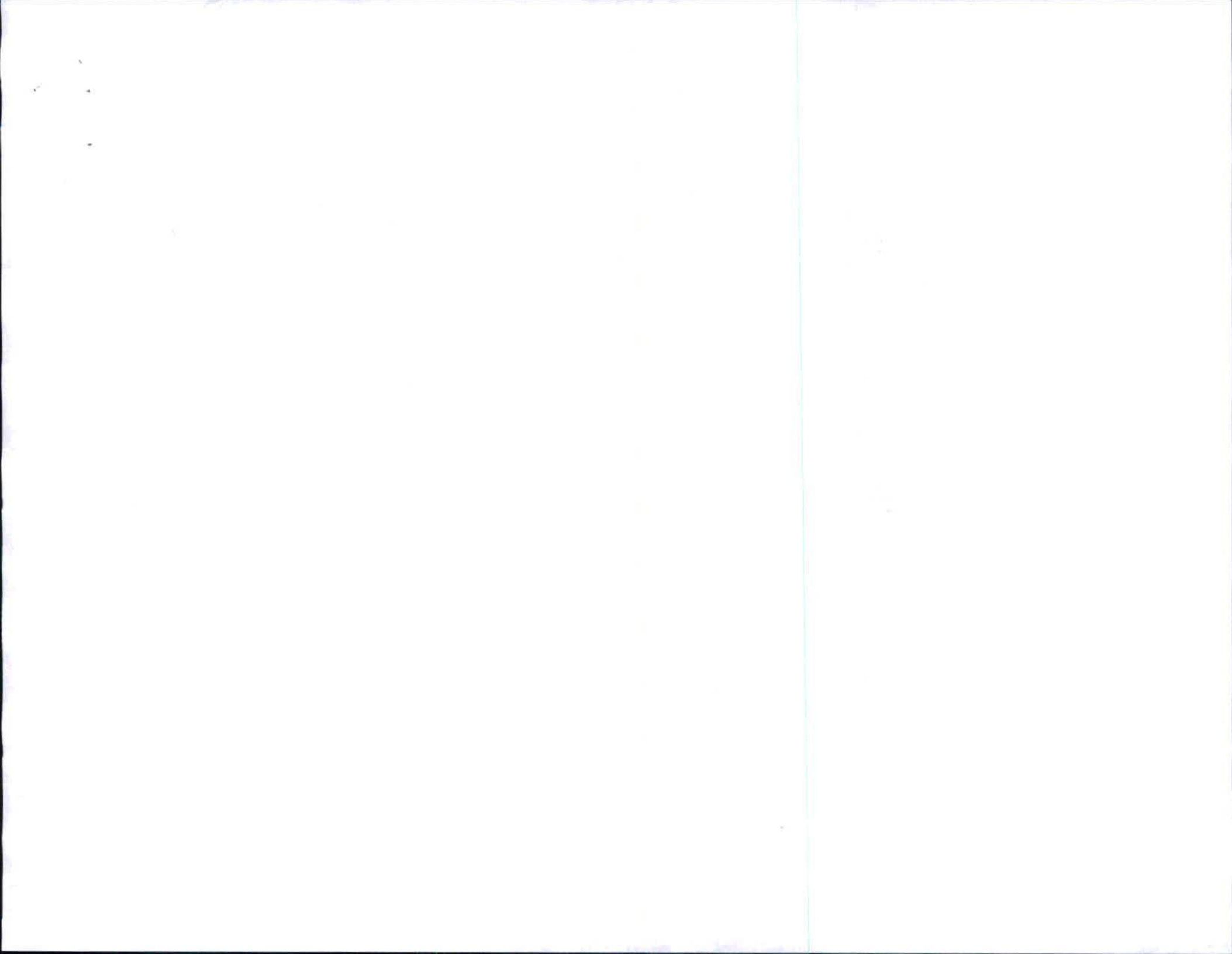
Comment: FINAL INSPECTION/W/O RELEASE

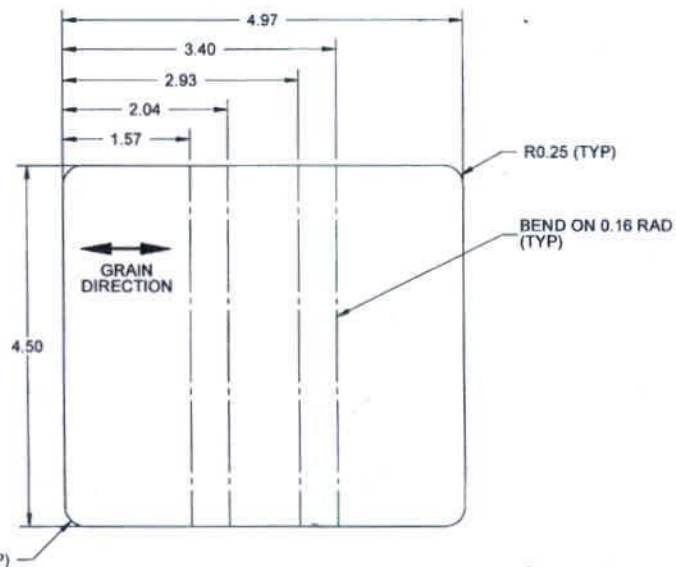
08/11/05

Job Completion



m-f 08-11-05

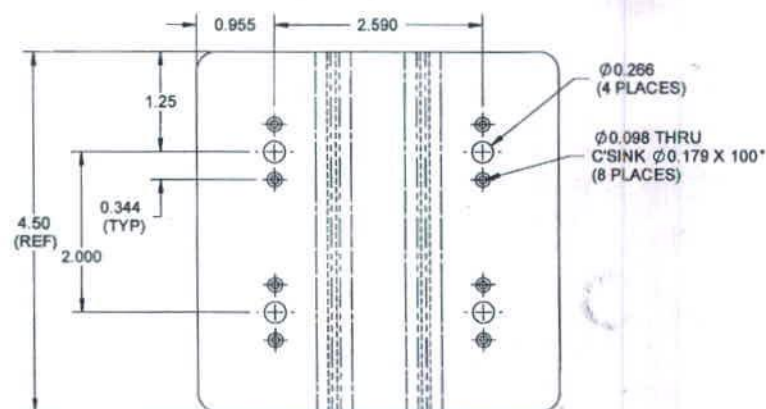




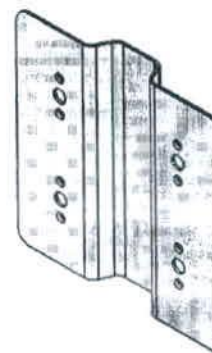
D3637-3F FLAT PATTERN



R0.25
08.11.04



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

W643184

08.12.04

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Ref	DRAWING NO.	REV. B
MFG. APPR.	Ref	D3637	SHEET 3 OF 3
APPROVED	Ref	TITLE	SCALE
DE APPR.	Ref	BRACKET	23
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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1.410
2540
W END



